

**Work Order ID 63959**

Monday, November 22, 2010 9:52:12 AM



Page 1

Item ID: D3827-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Inboard)

Start Date: 11/22/2010 Start Qty: 6.00

Required Date: 11/29/2010 Req'd Qty: 6.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-11-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3827

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3827-1 rib as per dwg D3827

2- drill holes using DT9435 jig and open to finish size as per dwg D3827

3- c/sink as per dwg

4- remove identification markings

5- deburr

6- weld bushing in rib as per dwg D3827

A/R S.S. Rod Batch: 111505

7- grind weld flush

8- deburr if necessary

SAD 10-11-24

LPL 10.12.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/10/12/07

Quality Control

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/10/12/07

Quality Control

(76)

150

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

SAD  
10-12-08

Packaging

(6)

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63959**

Monday, November 22, 2010 9:52:12 AM

Page 3

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Start Date: 11/22/2010 Start Qty: 6.00

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Required Date: 11/29/2010 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/12/08 DJ

WF  
10-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, November 22, 2010 9:52:16 AM

Page 1

Work Order ID: 63959

Parent Item: D3827-041

Parent Item Name: Rib Assembly (Inboz..d)

Start Date: 11/22/2010

Required Date: 11/29/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1

Manufactured

No

100

Each

40.0000

3

18



Bushing

Location

Loc Qty

Loc Code

ST084

21

56942

21

WA

19

54072

9

61379

10

M304TS0.750W.065

Purchased

No

100

f

386.6173

8

50.52632



304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

MAT

286.88115

112398

0

115494

4.4725

115593

282.40865

WA

99.736185

115274

4.712185

115901

95.024



*Pl 10-12-07*

*B63875 -> (16)*

*363876 -> (2)*



*SAD 10-11-24*

*50.5264*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 43959  
881011-22

D3827-041 RIB ASSY (INBOARD)

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3827-041	RIB ASSY (INBOARD)
2	3	D3750-1	BUSHING
3	1	D3827-1	RIB

RELEASED  
08/11/14

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.59 lbs

A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED	<u>ASS</u>		
MFG. APPR.	<u>MB</u>		
APPROVED	<u>MB</u>		
DE APPR.	<u>MB</u>		
DATE	08.09.23		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3827		REV. A	SHEET 1 OF 3
TITLE RIB ASSY (INBOARD)		SCALE	NTS
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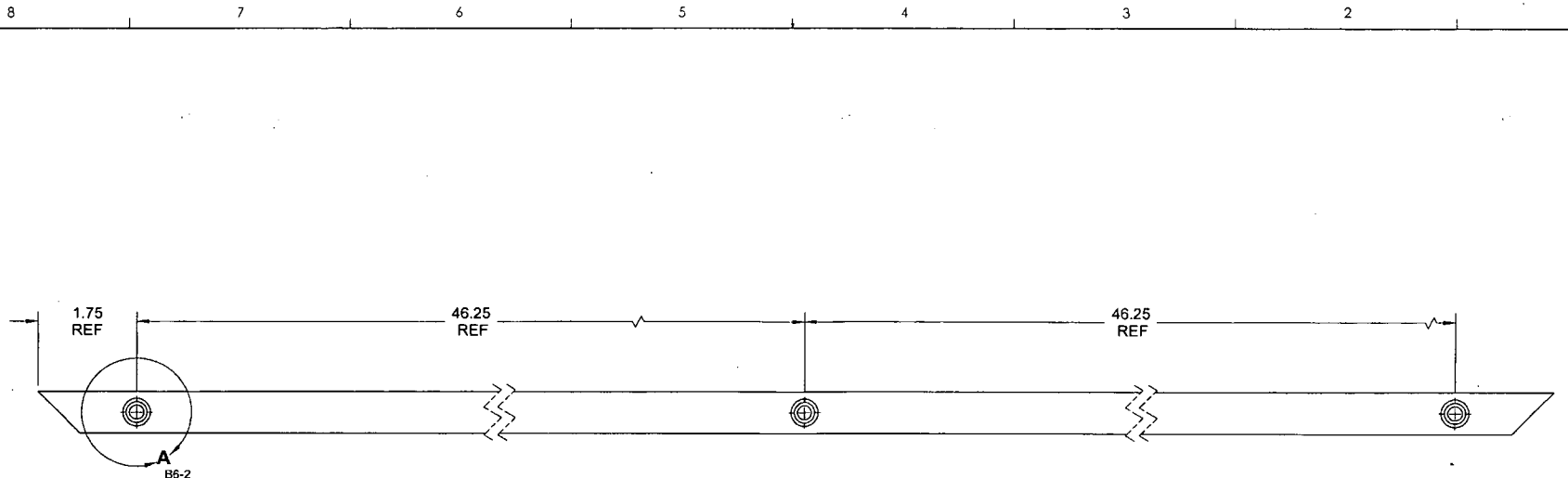
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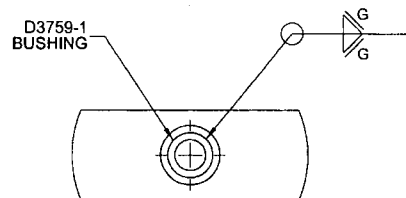
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**NOTE:** Date & initial all entries



**D3827-041 RIB ASSY (INBOARD)**



**DETAIL A**  
SCALE 2X  
C7-2  
3 PL

*w/b 63959*

**RELEASED**  
*08/11/18 N/A*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. <b>D3827</b>	REV. A
MFG. APPR.	MP	TITLE <b>RIB ASSY (INBOARD)</b>	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.	#	DATE <b>08.09.23</b>	
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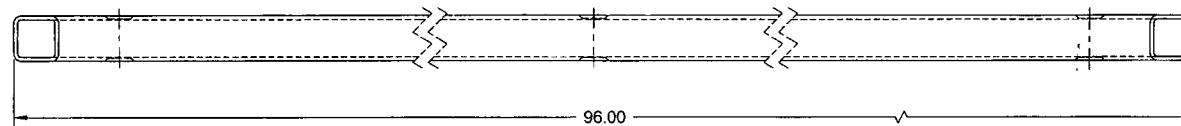
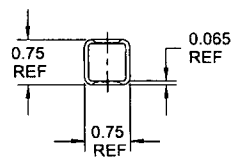
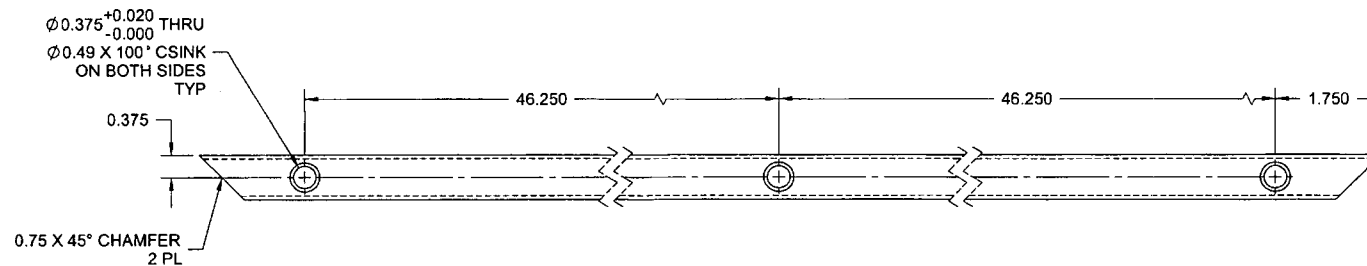
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**D3827-1 RIB**

*W/O 63959*

**RELEASED**  
*08/11/18*

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL REF. DART SPEC. M304TS0.750W0.065
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.55 lbs

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	<b>D3827</b>	SHEET 3 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>RIB ASSY (INBOARD)</b>	NTS
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